

Work Order ID 57512

April 8, 2010 7:17:58 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Required Date: 4/16/10 Req'd Qty: 20.00



Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3537	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

18 10-4-8

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(23)

304.063

110



QC2- Inspect parts off machine FAI/FAIB

0.00

18 10-4-8

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

control
723

QC

Memo

0.00

Quality Control

5/10/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57512

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Setup Start



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Item Name: Wearpad

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Start Qty: 20.00



Required Date: 4/16/10

Req'd Qty: 20.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

130



Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Draw
Number

1

Draw
Rev.

1

Plan
Code

1

Accept
Qty

20

Reject
Qty

0

Reject
Number

23

Insp.
Stamp

10-4-12 23

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

10-4-12 23

center
23

150



Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch A/R
 Weld hardcoat as per Dwg D3437

2059B Hardcoat

10-4-12 23

PL 10-4-15 23

W/O:		WORK ORDER CHANGES					
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Work Order ID 57512

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Item ID: D3537-3

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Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Required Date: 4/16/10 Req'd Qty: 20.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

S 10/04/10

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/10

counts
+23

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

-24 10/04/20

23 0

Memo
START TIME: 9:00 AM OVEN TEMPERATURE:
9:30 AM FINISH TIME: 3209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57512

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Item ID: D3537-3

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 4/08/10 Start Qty: 20.00



Required Date: 4/16/10 Req'd Qty: 20.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Stop

Sequence ID/
Work Center IDOperation
Description

190

QC3- Inspect Part Finish



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location: FP-17

0.00

41

10/04/20

23

Ø

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/20 JJ

MF 10-4-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 8, 2010 7:17:57 AM

Page 1

Work Order ID: 57512



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	34.2000	3.1368 	3.7 	4/8/10-4-8	

304/316 Sheet .063

	<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	<u>Location</u>		
	Main Warehouse		
	MAT20	34.2	
	113295	34.2	113298

23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57512
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

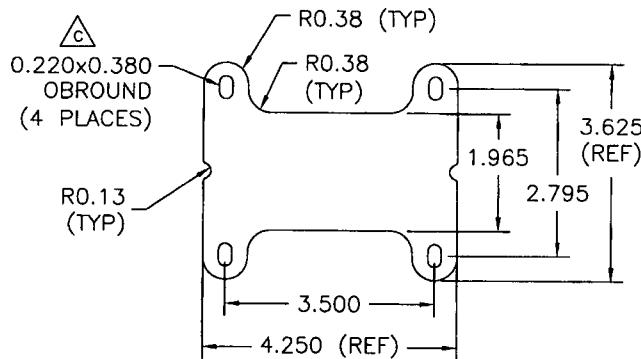
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

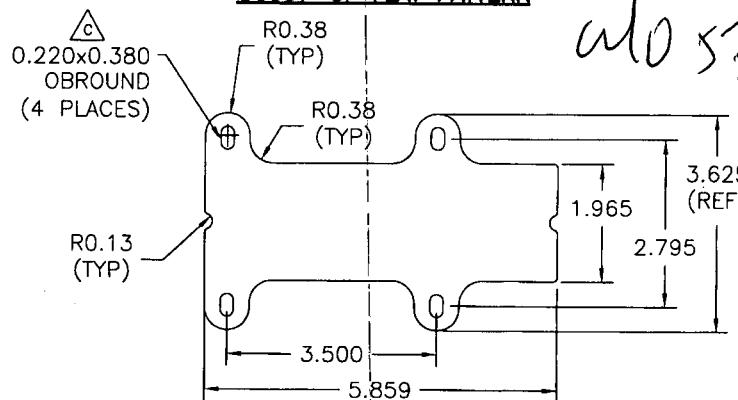
Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-4-9	Date:	10/04/95	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	<i>E</i>

D3537-1F FLAT PATTERN

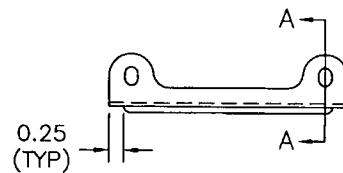


D3537-3F FLAT PATTERN

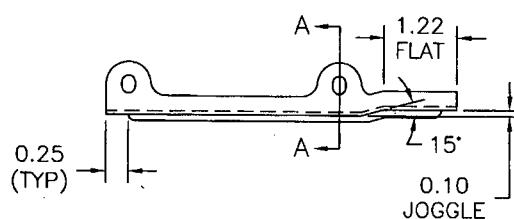


MO 57512

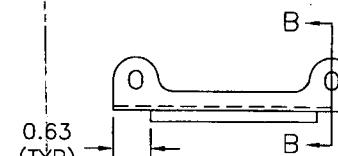
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

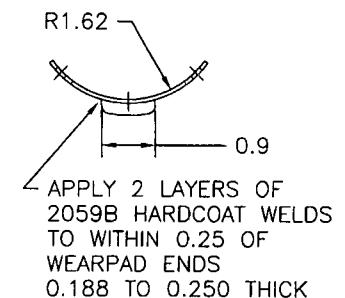


D3537-1/-3/-5/-7 WEARPAD NOTES

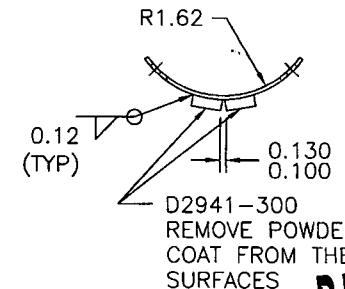
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

SECTION A-A

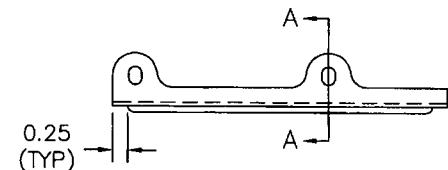


SECTION B-B



RELEASED
07.05.08 AM
per ECN
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. REV. C D3537
		SHEET 1 OF 1
DATE		TITLE WEARPAD
07.04.13		SCALE 1:2

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